

Date: Wednesday, 04/10/2006 2:11:43 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28873
 Estimate Number : 12175
 P.O. Number : N/A
 This Issue : 04/10/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 27024
 Written By : U
 Checked & Approved By : U
 Comment : Est Rev:A New Issue 06-02-03 JLM

Drawing Name : DUCT
 Part Number : D34761
 Drawing Number : D3476 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : N/A
 Due Date : 11/10/2006

Qty: 42 Um: Each

Additional Product

1 ASAP

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.4374 sf(s)/Unit Total : 1.7497 sf(s)

see pgs. 304/316 0.018 SHEET

Batch: M100843

11102376 M 06 10 16

M 06 10 13

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D3476

Dwg Rev: A

Prog Rev: A

M 06 10 16

M 06 10 13

(4)

(4)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 10 16

M 06 10 13

(4)

(4)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

M 06 10 13

M 06 10 13

(4)

(P70)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3476

3-Spot weld as per Dwg D3476 and Dart QSI 018

M.F. 06/10/13

M.F. 06/10/13

(2)

(2)

(P70)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3476-1 PAR #: WLT Fault Category: Prod/Eng. Assy ^{med & small} NCR: Yes No DQA: 20 Date: 06/11/03
 QA: N/C Closed: 20 Date: 06.11.03

NCR: <u>28873</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-16	2.0	2 parts made with 22 ga, To replace the 26 ga, cause there was none in stock. Only was Eng. approval by hazel change.	<i>[Signature]</i>	Parts unacceptable. to not fit. scrap & destroy. Replace with .018" mat'l.	<i>[Signature]</i> 08/10/16	<i>[Signature]</i> 06-10-16	<i>[Signature]</i>	<i>[Signature]</i> 06-10-16
06-10-17	2.0	4 new Received .018 ss.	<i>[Signature]</i>	4 new parts made with .018" mat'l, AS required.	<i>[Signature]</i> 08/10/16	<i>[Signature]</i> 06-10-16	<i>[Signature]</i>	<i>[Signature]</i> 06-10-16
06-10-17	5.0	2 parts spot welded i did not fit. B. M. Adapter, And Motor casing where not exactly the same size, casing A terrible fit.	<i>[Signature]</i> <i>Dan Dutton</i>	1 part for next ass'y. 1 part scrapped & destroyed.	<i>[Signature]</i> Matthew Nunn 06/10/02	<i>[Signature]</i> 06/10/02	<i>[Signature]</i>	<i>[Signature]</i> 06.11.02

NOTE: Date & initial all entries

Date: Wednesday, 04/10/2006 2:11:44 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 28873

Part Number: D34761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/11

INSPECT WORK/INSPECT SPOT WELD



Comment: INSPECT WORK/INSPECT SPOT WELD

06-10-17

③

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location *GA*

SB 06/11/1

③

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/03

③

Job Completion



U 06-11-02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

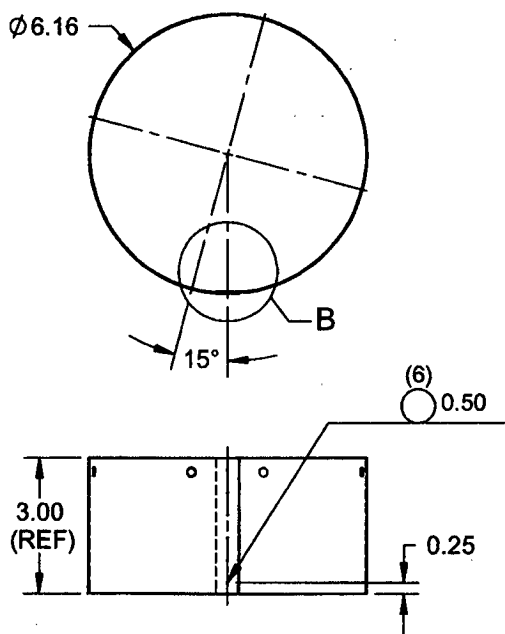
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

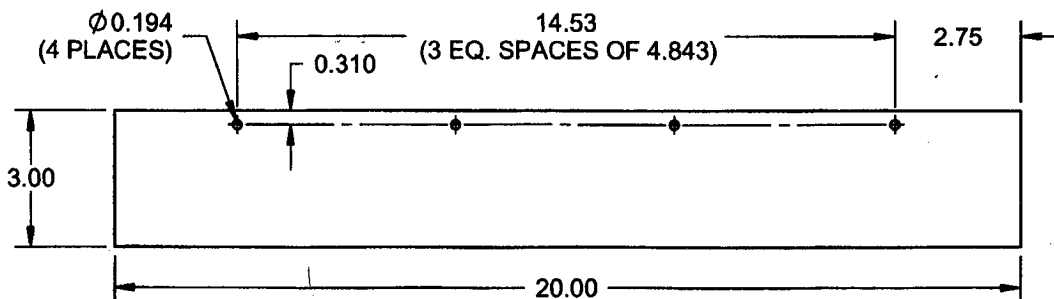
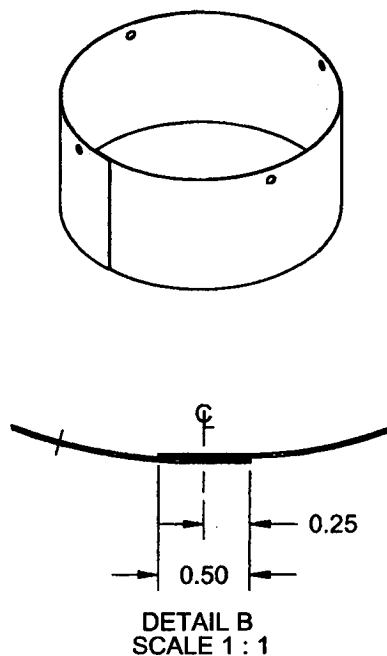


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. A SHEET 3 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

[Handwritten] 06.04.03



D3476-1 DUCT



D3476-1F DUCT FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

[Handwritten] 22
FOR 1
PART ONLY
06.10.13

COPYRIGHT © 2006 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

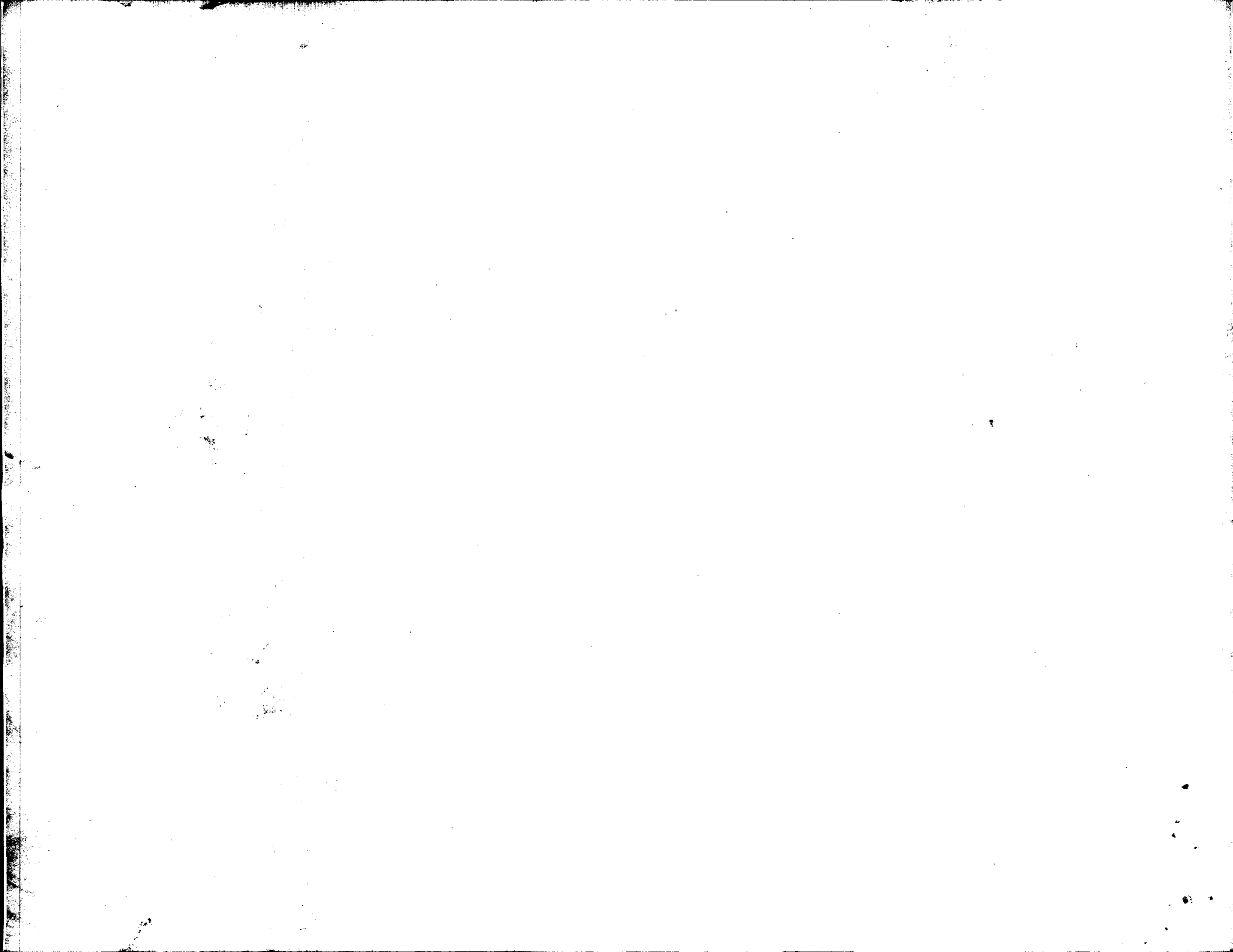
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NO. 37

AMS-W-6858A

~~AWS D17.1.2001~~

QUALIFICATION TEST RECORD

Name Helanie FoutouxJoint Welding Procedure SpotweldingPart number and Job number D3476-1 B28873 / D3476-043 B28565

TEST WELDS REQUIRED.

BASE METAL SS.WELDING PROCESS SpotweldPenetration Complete ☐ Partial ☐Single Weld ☐ Double Weld ☐Current AC ☐ DC ☒Backing YES ☐ NO ☐

	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into

Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐Penetration Pass ☒ Fail ☐Crossbolt Spacer Pass ☐ Fail ☐

AMS-W-6858A

The above named individual is qualified in accordance with ~~AWS D17.1.2001~~ to weldDate of Test Coupon 06.10.17Qualifier Jam Hall